

Work Order ID 146778

Tuesday, May 24, 2016 9:52:40 AM

146778

Page 1

Item ID: D3706-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lock Bracket Assembly
Start Date: 6/7/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 6/15/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: u Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3706	C

100 Weld per dwg A/R Aluminum rod Batch: _____ 0.00

100

Large Fab

Memo 0.00

Large Fab

1- WELD LOCK BRACKET TO GUIDE AS PER DWG

2- GRIND WELD FLUSH WITH FLAT SURFACE WHERE INDICATED AS PER DWG

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo 0.00

Quality Control

120

QC5- Inspect part completeness to step on W/O 0.00

120

QC

Memo 0.00

Quality Control

Closed

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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Page 2

Item ID: D3706-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lock Bracket Assembly

Start Date: 6/7/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/15/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC7-Inspect Chemical Conversion Coat	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	1- MASK THREADS PRIOR TO PAINTING AS PER DWG								
	2- POWDER COAT:								
	Start Time: _____								
	Oven Temperature: _____								
	Finish Time: _____								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : _____					

Work Order ID 146778

Tuesday, May 24, 2016 9:52:40 AM

146778

Page 4

Item ID: D3706-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lock Bracket Assembly

Start Date: 6/7/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/15/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Receive & Inspect for Damage & Mat'l Certs

0.00

190

Packaging

Memo

0.00

Packaging

200

QC21 - Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

DAS
21
9-89

MAR 28 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : _____					

Picklist Print

Tuesday, May 24, 2016 9:52:39 AM

Page 1

Work Order ID: 146778

146778

Parent Item: D3706-041

D3706-041

Parent Item Name: Lock Bracket Assembly

Start Date: 6/7/2016

Required Date: 6/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.12.03 NEW ISSUE DD VERF:JLM
IPP REV:B 13.01.15 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3706-1		Manufactured	No				Each	0.0000		1			
D3706-1									**				
Lock Bracket													
D3706-3		Manufactured	No				Each	4.0000		1			
D3706-3									**				
Guide													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				WA002				4					
				139486				4					
MS21209F1-15		Purchased	No				Each	278.0000		1			
MS21209F1-15									**				
HELI COIL													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				CA				178					
				m129682				178					
				ST297				100					
				m130626				22					
				m130799				78					
MS21209-F1-20		Purchased	No				Each	30.0000		1			
MS21209-F1-20									**				
HELI COIL													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST297				30					
				m133932				30					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

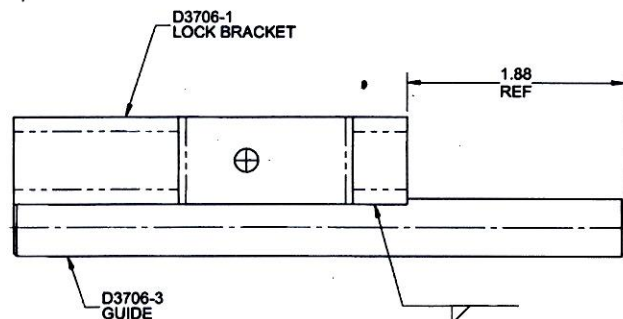
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : _____					

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3706-041	LOCK BRACKET ASSEMBLY
1	1	D3706-1	LOCK BRACKET
2	1	D3706-3	GUIDE
3	1	MS21209-F1-20	HELI-COIL, SCREW LOCKING (RED)
4	1	MS21209-F1-15	HELI-COIL, SCREW LOCKING (RED)

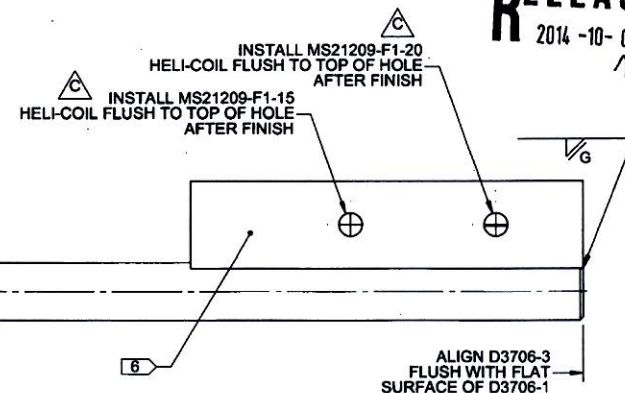
Wb 146778

RELEASED
2014-10-07



ALIGN D3706-3
FLUSH WITH FLAT
SURFACE OF D3706-1

D3706-041 LOCK BRACKET ASSEMBLY



D3706-041 NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (PERMANENT INK MARKER)
- 7) WEIGHT: 0.28 lbs
- 8) WELDING: PER DART QSI 004

C	MS21209-F1-15 WAS MS21209-F115, MS21209-F1-20 WAS MS21209-F120, REASON: PAR13-302	DB	14.08.22
B	ADD D3706-041; ADD TAPPED HOLES FOR HELI-COIL ON D3706-1 (ZNS B7-4/7); 0.786 +0.000/-0.030 WAS 0.80 (ZND7-2). REASON: CIR12-4.	MB	12.11.29
A	NEW ISSUE	MB	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	MB	DRAWING NO.	REV. C
MFG. APPR.	DD	D3706	SHEET 1 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	INSTRUMENT PANEL LOCK	NTS
DATE	14.08.22	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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